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D3537-1

Job Sheet 201422



Part No: D3537-1

Job Qty: 50 pcs

Part Name: Wearpad



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3537 REV:F IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD
verf:JLM IPP REV:C 18.11.09 AS PER DWG REV:F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
105	Waterjet - Flow - 1	50 pcs		11/15/19	0.17	2.15	Waterjet - Flow		
110	QC 2	50 pcs		11/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S225791



Part: D3537-1

Job No: 201422

Serial No/Batch: S225791

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/19

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10/3/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
125 QC 8	50 pcs	11/15/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	OCT 24 2019
				QC 8 - 52	DAS 40 9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	50 pcs	11/15/19	0.25 0.65	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	NOV 05 2019
150 QC 5	50 pcs	11/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	DAS 81 9-89
				QC 5 - 58	
				QC 5 - 68	NOV 05 2019
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Automated Welding - B4B	50 pcs	11/15/19	0.00 3.71	Automated Welding - 1 - B4B	
170 QC 10	50	11/15/19	0.00 0.00	QC 10 - 10	

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180 QC 5	50 pcs	11/15/19	0.00 0.00	QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	12
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
210 Packaging 3-1 - Stock - B4B	50 pcs	11/15/19	0.00 0.00	QC 5 - 50	12
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	50 pcs	11/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
				Broussard	

Part Op 105 - 1-Cut D3537-1 as per Dwg D3537 Dwg Rev: F Prog Rev: F 2-Debur if necessary

Descriptions: 125 - (QC8- Inspect parts - second check)

140 - (Form as per dwg)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Automated welding) ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M139018

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: KPG01)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	5.3000 sf (.106 ea)	105-Waterjet - Flow - 1	<u>5200442</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M304S16GA	5	426	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches ± 0.010	4.260 4.240	<u>4.252</u>	
2	Wearpad	3.500inches ± 0.010	3.510 3.490	<u>3.502</u>	
3	Wearpad	1.970inches ± 0.030	2.000 1.940	<u>1.968</u>	
4	Wearpad	3.630inches ± 0.030	3.660 3.600	<u>3.620</u>	
5	Wearpad	2.420inches ± 0.010	2.430 2.410	<u>2.416</u>	
6	Wearpad	0.220inches ± 0.010	0.230 0.210	<u>0.225</u>	
7	Wearpad	0.375inches ± 0.010	0.385 0.365	<u>0.379</u>	
8	Wearpad	0.063inches ± 0.010	0.073 0.053	<u>0.064</u>	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐ Contamination ☐
Bending ☐ Misaligned/off center ☐
Crushing ☐ BOM/Route ☐
Cracks ☐ Broken/Damage/Defect ☐
Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐
Marks/Chatter ☐ Drill Holes ☐
Mislabeled ☐ Fit/Function ☐

Power Loss/Surge ☐ Positioned Wrong ☐
Folio/Program ☐ Outside Tolerance ☐
Grain Direction ☐ Drawing ☐
Weld ☐ Finish ☐
Wrong Stock Pulled ☐ Part Lost/Missing ☐
Out of Sequence ☐ Misread ☐
Off-set/Set-up ☐

Other/Details: _____